

# Work Order ID 54318

December 7, 2009 3:10:34 PM



Page 1

Item ID: D3770-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Tube

Start Date: 07/12/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 21/12/2009 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: PL

Date: 09/12/07

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3770

Rev B

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-cut tube to length as per dwg D3770 2-drill holes thru to finish size as per dwg D3770 Using DT9412 3- deburr

M-k 10/01/04

40X

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ 8/10/05

counter  
+40

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

BR 10-01-5 - 40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

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Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC3- Inspect Part Finish

0.00



M 10/01/05

QC

Memo

0.00

Quality Control

40x

0

140

Identify as per dwg & Stock Location: 254

0.00



Packaging

Memo

0.00

Packaging

10-1-5

40x 5

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/06

ME 10-01-05

W/O:		WORK ORDER CHANGES					
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# Picklist Print

December 7, 2009 3:10:38 PM

Page 1

Work Order ID: 54318



Parent Item: D3770-3



Parent Item Name: Tube

Start Date: 07/12/2009

Required Date: 21/12/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T1.000W065 		Purchased	No			100	f	58.3994	76.3158			
6061T6 RD TUBE 1.00 x .065w												

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

58.3994082

110778

2.18

111029 ✓

56.2194082

M113511 ✓

m. k  
13X  
27X  
10/01/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

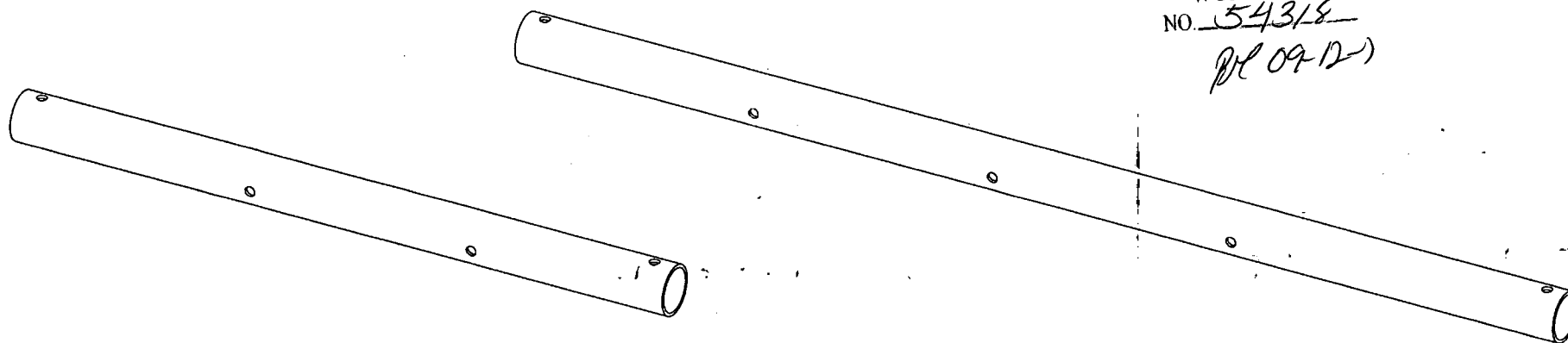
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**NOTE:** Date & initial all entries

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER NO. 54318  
*080912*



**D3770-1 TUBE**

**D3770-3 TUBE**

RELEASED  
08-07-10/10A

- NOTES:**  
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: D3770-1, 0.25 lbs  
D3770-3, 0.40 lbs

B	CHANGE HOLES SIZE TO 0.201	HS	08.06.23
A	NEW ISSUE	HS	08.06.04
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	HS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3770	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TUBE	NTS
DATE	08.06.23	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
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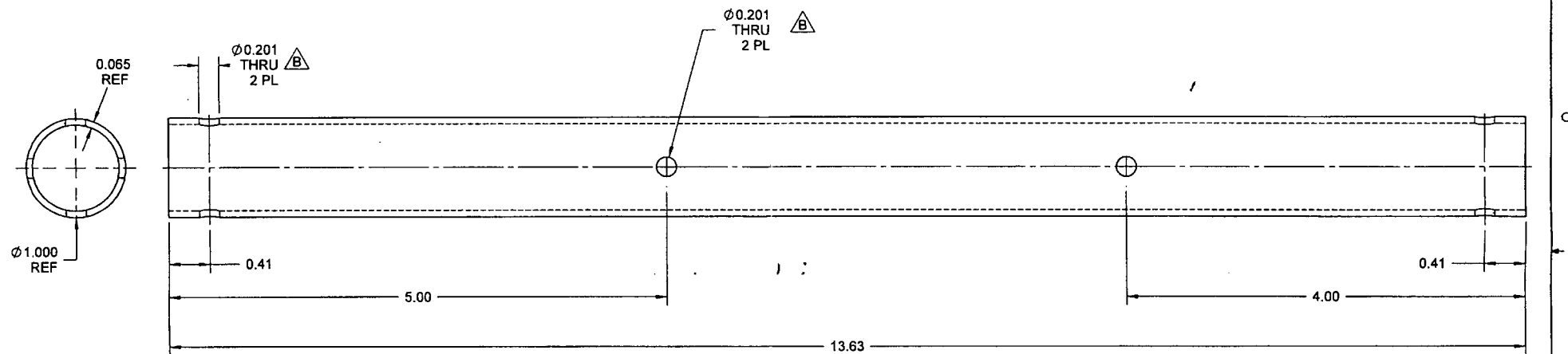
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**NOTE:** Date & initial all entries





**D3770-1 TUBE**

RELEASED  
08.07.10

DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D3770	SHEET 2 OF 3
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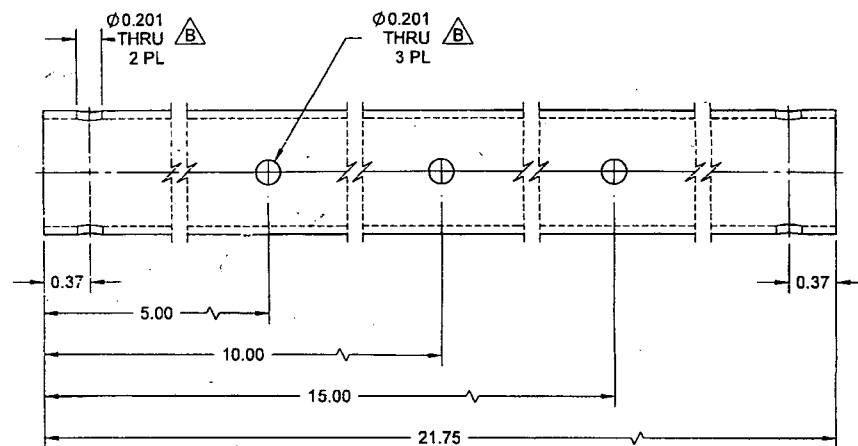
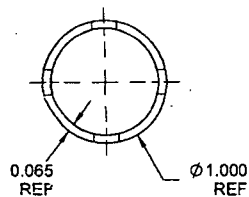
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**D3770-3 TUBE**

RELEASED  
05.07.10/11/12

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DRAWN	HS		
CHECKED	PL	DRAWING NO.	REV. B
MFG. APPR.	PL	D3770	SHEET 3 OF 3
APPROVED	PL	TITLE	SCALE
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